

# Work Order ID 50787

July 22, 2009 12:47:35 PM

Item ID: D3948-041

Revision ID: B

Item Name: Plate, Anchor

Start Date: 07/22/2009 Start Qty: 12.00

Required Date: 07/27/2009 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: *mf*

Date: 09-07-22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3948

B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3948-1

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

IB 9-7-23

(17)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

IB 9-7-23

07/24/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 50787



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Item ID: D3948-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Plate, Anchor

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Required Date: 07/27/2009 Req'd Qty: 12.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

0.00



Small Fab

Memo

0.00

Small Fab

1- countersink holes as per dwg

2- deburr if necessary

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ 808/07/23

①7 φ

808/07/27 ①4

⇒ 808/07/27

\* ①4 φ

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

BR 09-07-27 (14)

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

gl 09-07-27 (14)

170

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/7/27 (14) sy

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Dart Aerospace Ltd**

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July 22, 2009 12:47:35 PM



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Stop



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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/29 JJ

see previous sheet for  
closing w/o signoff.

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Picklist Print

July 22, 2009 12:47:35 PM

Work Order ID: 50787

Parent Item: D3948-041RevB

Parent Item Name: Plate, Anchor


Comments:

Start Date: 07/22/2009

Required Date: 07/27/2009

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	135.2173	1.3705			
												
6061-T6 .063 Sheet												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

MAT

135.2173316

109463

0.6447

110551

134.572632

MS21059L3

Purchased

No

170

Each

839.0000

24.0000



Nut Plate

110551 18 9-7-23

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

839

109962

339

111925

500

MS20426AD3-3

Purchased

No

170

Each

8,118.000

48.0000



Rivet

109962 9/7/27 54

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

8118

1563

0

19099

4776

7681

3342

7681 9/7/27 54

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NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	50787
<b>Description:</b>	<b>Part Number:</b>	D3948-1
<b>Inspection Dwg:</b>	<b>Rev:</b>	<b>Page 1 of 1</b>

## FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**      ☐ **Prototype**

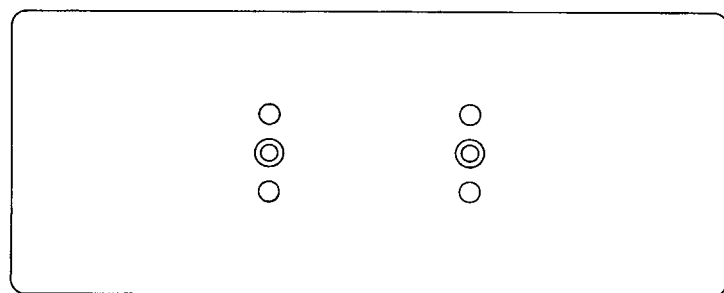
[illegible]

Measured by: PB	Audited by: S	Prototype Approval: N
Date: 9-7-23	Date: 09/07/23	Date: 1/9

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

# PARTS LIST

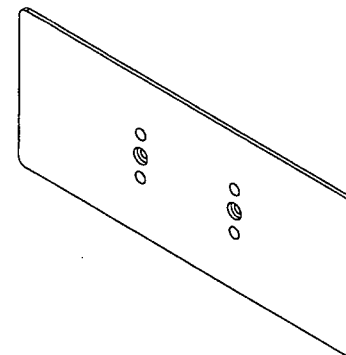
ITEM	QTY	P/N	DESCRIPTION
1	X	D3948-041	PLATE, ANCHOR
2	1	D3948-1	PLATE
3	2	MS21059L3	NUTPLATE (OR MS21059-3)
4	4	MS20426AD3-3	RIVET



**D3948-041 PLATE, ANCHOR**

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3948-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs



50787

RELEASED  
09/06/08

B	-3F NOW MADE FROM 304 SS (ZN A8-5), 0.063 THICK WAS 0.040 (ZN A8-3, A8-5), -043/-3/-3F WIDER (ZN B6-4, B6-5)	CP	09.06.08
A	NEWISSUE	CP	09.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.08		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3948** REV. B  
SHEET 1 OF 5  
TITLE **PLATE, ANCHOR** SCALE NTS

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**Dart Aerospace Ltd**

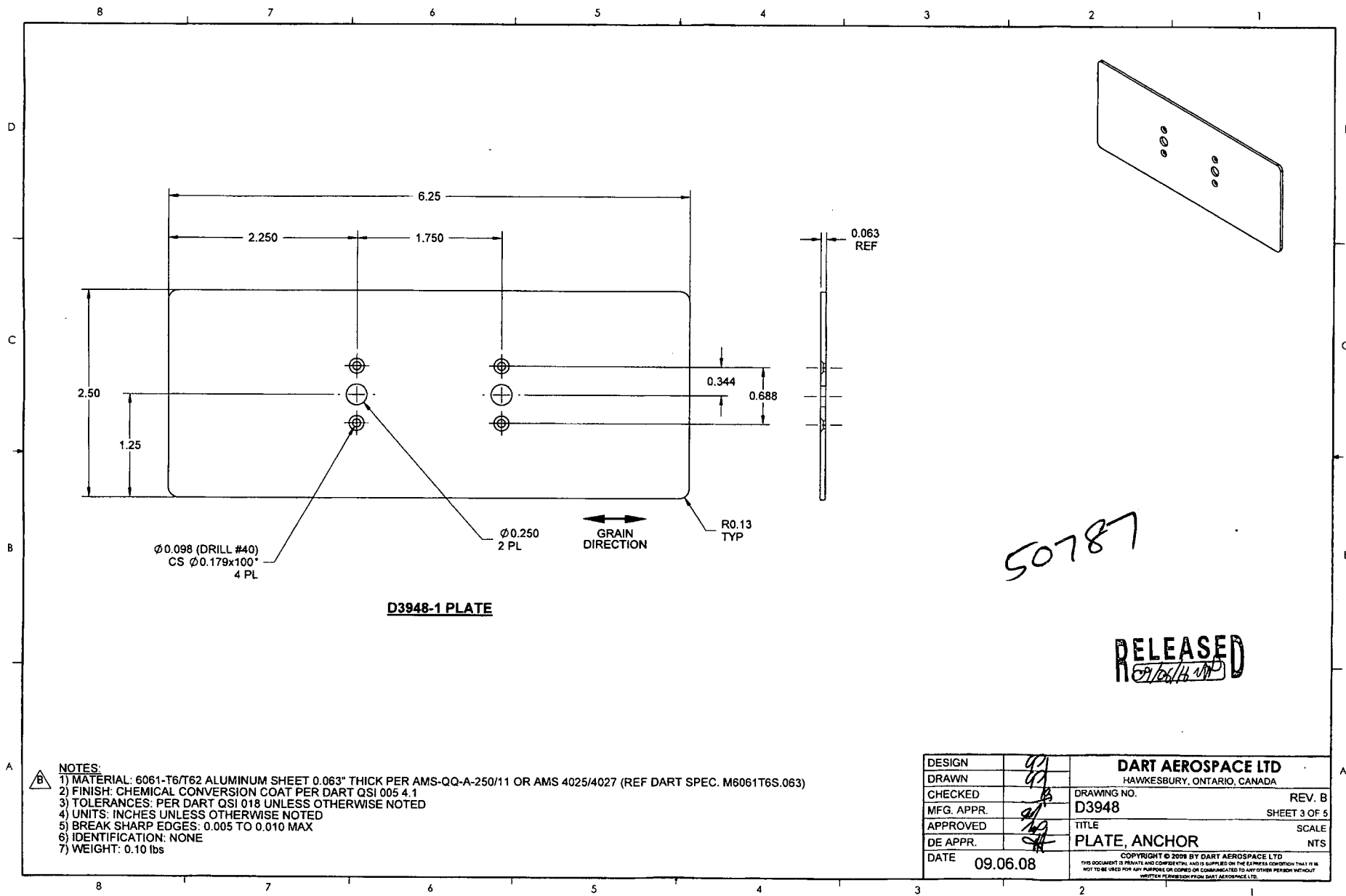
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**NOTE:** Date & initial all entries



50787

RELEASED  
9/26/14

- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.063" THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC. M6061T6S.063)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.10 lbs

DESIGN	97	DART AEROSPACE LTD	
DRAWN	97	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. B
MFG. APPR.	97	D3948	SHEET 3 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	PLATE, ANCHOR	NTS
DATE	09.06.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



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